
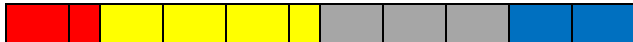



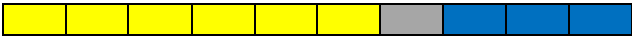





BRAND NAME		HARDNESS HRc (BHN)	RATING OF IMPORTANT PROPERTIES	RECOMMENDED APPLICATION
MODERATE ABRASION - IMPACT				
Zedalloy 250 AC / DC -	23-27 (240-260)	 C: 0.15%, Cr: 1.0%	Gears, Pinion teeth, Track links, Rollers and Sprockets, Pulleys, Shafts, Couplings, Spindles, Gear wheels, etc.	
Zedalloy 350/ AC / DC - Zedalloy 350-LH AC / DC +	35-40 (330-380)	 C: 0.18%, Cr: 3.0%	Excavators, Girth gears of Cement & Power plants, Supporting rollers of Kiln tyres, Cams, Conveyor parts, Gear shafts, Crane wheels, etc.	
Zedalloy 550 AC / DC - Zedalloy 550-LH AC / DC +	54-56 (540-580)	 C: 0.55%, Cr: 6.0%, Mo: 0.6%	Dis-integrator hammers, Excavator teeth, Caterpillar treads, Metal cutting & forming tools, Hammers, Shear blades, Bulldozer blades, Bucket lip, Cane cutting knives, etc.	
Zedalloy 650 Zedalloy 55 AP Zedalloy-600 AC / DC +	58 (600)	 C: 0.6%, Cr: 6.0%, V: 0.25% (650) C: 0.5%, Cr: 9.0%, Si: 0.70%, Mn: 0.80% (55 AP) C: 0.6%, Cr: 9.0%, Mo: 0.9%, V: 0.4% (600)	Paper Cutting Knives Crane Wheels, Shear Blades, Crushers, Hammers, Drilling Bits, Punches, Dies, Oil Expeller Worms, Mine Rails, Conveyor Parts, etc.	
HIGH IMPACT - WORK HARDENING TYPE				
Zedalloy 12 Mn / Zedalloy 16 Mn AC / DC +	AW- (200)	 C: 0.8%, Mn: 12.0% (12 Mn)	Rock Crushing Jaws, Dredger Bucket Teeth, Austenitic Mn Steel Castings, Cement Grinding Rings, Mn Steel Rails, Crusher	
	WH- (500)	C: 0.7%, Mn: 15.0%, Ni: 3.5% (16 Mn)		

APPLICATION WISE GRADATION OF HARDFACING ELECTRODES


			Mantles, Hammers, Suitable for Build up & Cushioning, etc.	
HIGH IMPACT – WORK HARDENING & CORROSION RESISTANT TYPE				
Zedalloy 16 Cr / Zedalloy 20 Cr AC / DC +	AW- (200-250)	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div>C: 0.30%, Mn: 5.0%, Cr: 16% (16 Cr) C: 0.25%, Mn: 3.0%, Cr: 19.0%, Ni: 4.5% (20 Cr)</div>	Dipper teeth & lips, Coal mining cutters, Rock crusher, Dredger cutter teeth, Pulveriser plows, Pump housing, Conveyor rolls, Buckets, etc.	
	WH-(500-520)			
HIGH ABRASION & ELEVATED TEMPERATURE RESISTANT TYPE				
Zedalloy K AC / DC +	58 (600)	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div>C: 0.6%, Cr: 4.5%, Mo: 8.5%, V: 0.8%, W: 1.0%</div>	Blanking and Forming dies, Hog & Chipper knives, Wood working tools, Shear blades, Cutting tools, Mining tools, Rolling mill guides, etc.	
Zedalloy Bell AC / DC +	At RT: 52–55	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div>C: 0.21%, Cr: 1.6%, Mo: 5.7%, Ni: 5.3%, V: 0.1%</div>	Blast furnace Bells & Hoppers, Tong pins, Hot shears, Steel mill equipment, etc.	
	At 500°C: >52			
Zedalloy 680 AC / DC +	At RT: 63	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div>C: 4.6%, Cr: 22.0%, Mo: 7.0%, Nb: 1.6%, W: 2.2%, V: 1.1%</div>	Clinker grinders, Sinter handling equipment, Sinter star breakers, Coke pusher shoes, Coal burner nozzles, etc.	
	At 500°C: >55			
EXTREME ABRASION RESISTANT TYPE				
Zedalloy-VB/ Zedalloy 604/ Zedalloy 16 AC / DC +	58 (600)	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div>C: 2.5%, Cr: 3.5%, Si: 3.0% (VB) C: 3.0%, Cr: 9.0%, Si: 1.0% (604, no slag) C: 4.0%, Cr: 9.5%, Mo: 1.8% (16)</div>	Concrete Mixer Blades, Scraper Blade, Oil Expeller Worm, Screw Conveyor, Muller Blade, Cement Die Rings, Excavator Teeth, Plough Shares, etc.	
Super Zedalloy/	58 (600)	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div>	Coke chutes, Ceramic industries,	

APPLICATION WISE GRADATION OF HARDFACING ELECTRODES

Zedalloy 605 AC / DC +		C: 4.0%, Cr: 32.0%, Mn: 1.0%, Si: 0.70% (SZ) C: 4.0%, Cr: 32.0%, Mn: 1.0%, Si: 0.70% (605, ns)	Cement clinker crushing rollers, Cultivator shovels, Plough shares, Edge runner scrappers, Screws, Mining, Agriculture and Earth moving equipment, etc.	
Maganacane AC / DC +	55-57 (550-580)	 C: 3.8%, Mn: 1.0%, Si: 2.8%, Cr: 28.0%, V: 0.2%	For Spot-Arc building, Roughening of chilled cast iron rolls, Sugar mill rolls, Sand mixing blades, Scrapers, Screw flights, Mixing paddles, etc.	
HIGH TEMPERATURE IMPACT, OXIDATION & ABRASION RESISTANT TYPE				
Zedalloy CoCr-A AC / DC -	35-40 (320-370)	 C: 1.0%, Cr: 28.0%, Ni: 1.2%, W: 4.1%, Co: Bal.	Valve & Valve seats, Sealing surfaces, Conveyer screws, Hot pressing tools, Hot shear blades, Dies and cutting edges in Chemical, Rubber, Oil, Sugar industries and Steel mills, etc.	

HIGH TEMPERATURE OXIDATION, IMPACT & METAL TO METAL WEAR RESISTANT				
Nimoten Plus 535A AC / DC +	32-39	 C: 0.09%, Cr: 2.5%, Ni: 2.0%, Mo: 1.3%, V: 0.10%	Repair of large hot working dies & forging dies, Repair of H11, H13 & DB6 type die blocks, High tensile steel machinery parts	
Nimoten Plus 535B AC / DC +	38-42	 C: 0.10%, Cr: 2.8%, Ni: 2.1%, Mo: 1.4%, V: 0.15%	Filling die impressions in forging dies, Ni-Cr-Mo steels in chemical plants, Crack repair in Ni-Cr hot working dies, High tensile steel	

APPLICATION WISE GRADATION OF HARDFACING ELECTRODES

			machinery parts	
Nimoten HFD AC / DC +	50-54	 <p>C: 0.20%, Cr: 4.1%, Ni: 0.4%, Mo: 2.4%, W: 2.7%</p>	Press forging dies, Hot piercing punches, Impactor dies, Screw press dies, Trimming & Blanking dies, Forming dies, Shallow repair in dies, Parts of earth moving equipment	

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